

Work Order ID 144772-2
May 05, 2016 9:21:10 AM

144772

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Item ID: D5106-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket
Start Date: 5/13/2016 Start Qty: 20.00 *20* 20 SLK
Required Date: 5/27/2016 Req'd Qty: 20.00 *20* 20 SLK
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: MJS Date: MAY 05 2016 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5106	A

100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

Cut blank to 2.63" long

3.40

20 0 DAS 44 9-89 16-05-11

110

0.28

110

HAAS 1

HAAS CNC vertical machine #1

Memo

1-MILL as per folio FB332&dwg.

FOLIO REV: AA

DWG REV: A

2-Deburr as required

10.60

20 0 DAS 14 9-89 16/05/14

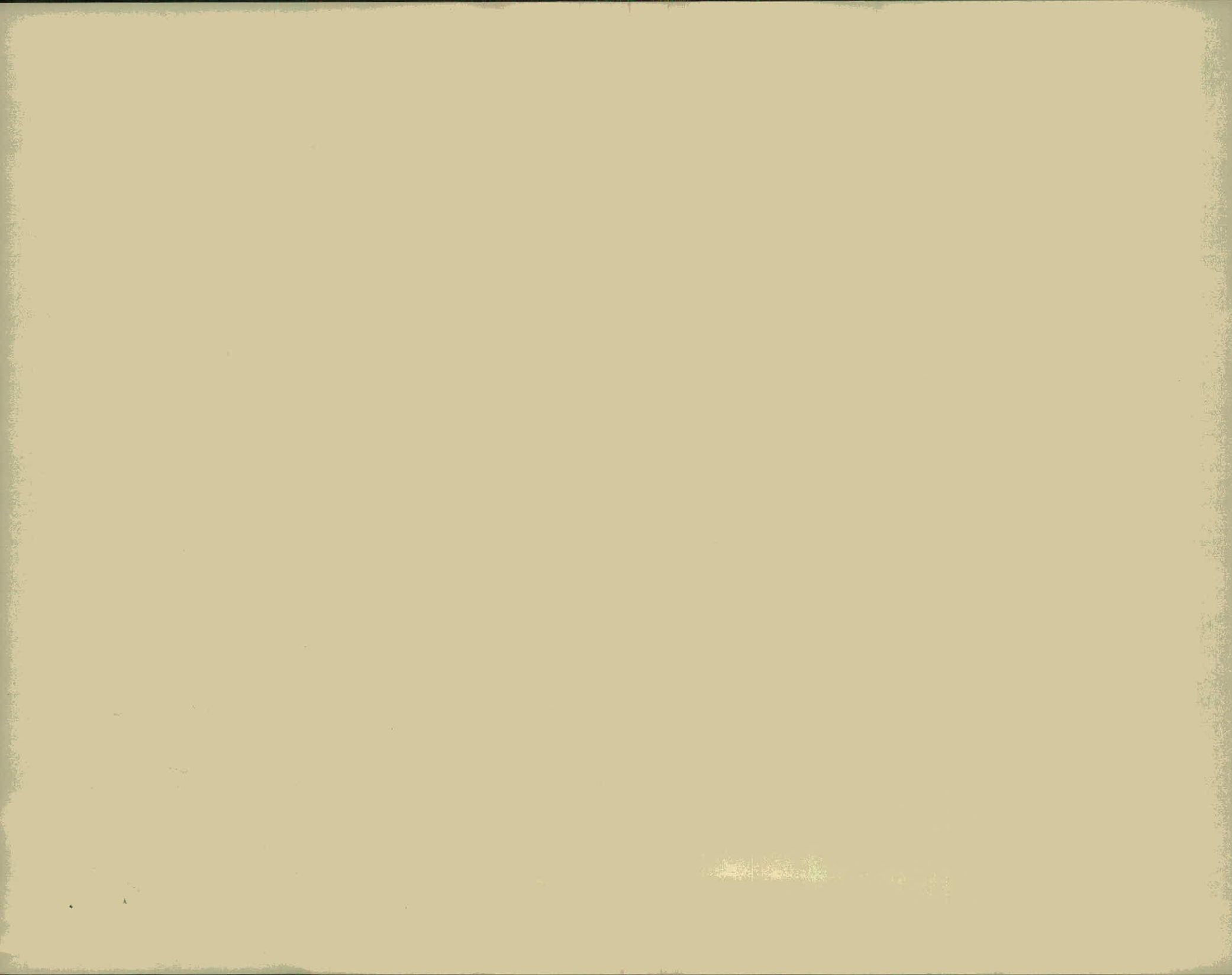
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.40				20	0		DAS 44 9-89 16/05/17
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>St12</u> Memo	0.00 0.20				20			MAY 18 2016 DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 2.00							16/5/18 JF MCS MAY 18 2016

Picklist Print

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Work Order ID: 144772

144772

Parent Item: D5106-1

D5106-1

Parent Item Name: Bracket

Start Date: 5/13/2016

Required Date: 5/27/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV A RQ VERIFIED BY DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	8.8639	0.219	4.610526	DAS 44 9-89	16/05/11	
M.303B2 000X1 750											**		
303 BAR 2" X 1.750"													

Location

Loc Qty

Loc Code

MAT008

8.8639

m129286

0.203

m132117

3.9703

m133547

4.6906

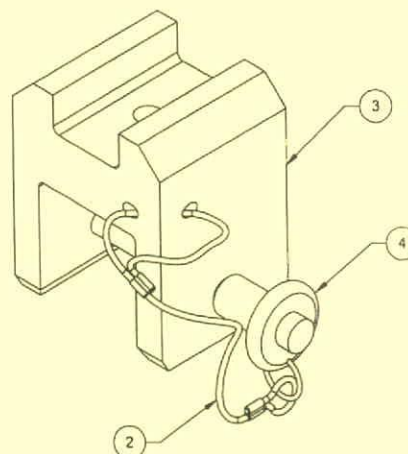
134734

4.5'





ITEM	QTY -041	P/N	DESCRIPTION
1	X	D5106-041	BRACKET ASSEMBLY
2	1	D2690-6	LANYARD ASSEMBLY
3	1	D5106-1	BRACKET
4	1	MS17984-C418	PIN, QUICK RELEASE (NASM17984-C418)



D5106-041 BRACKET ASSEMBLY

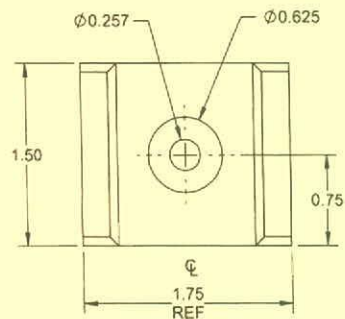
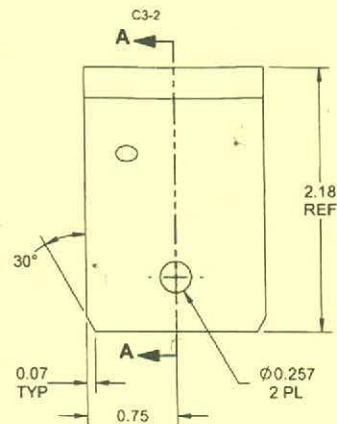
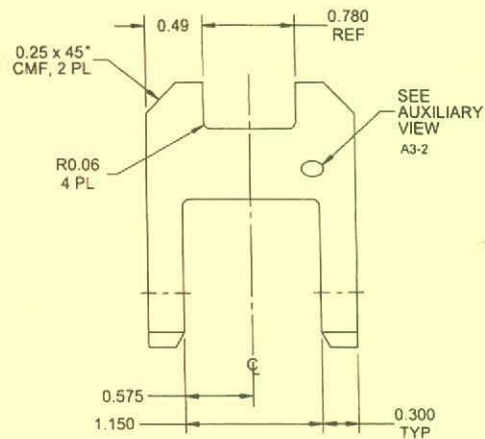
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.84 lbs
- 8) ASSEMBLE D2690-6 IN CONJUNCTION WITH D5106-1 & MS17984-C418
- 9) ENSURE THAT MS17984-C418 PIN CAN BE REMOVED FROM HOLE COMPLETELY

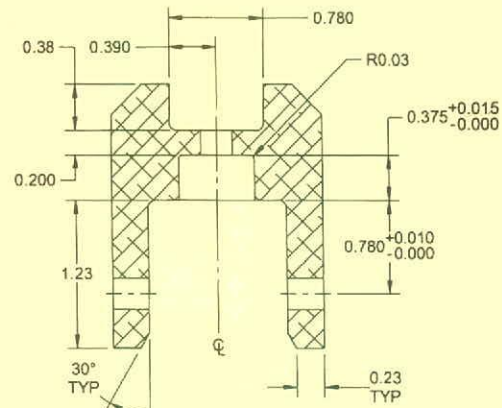
A	NEW ISSUE	RF	14.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5106	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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2014-07-24

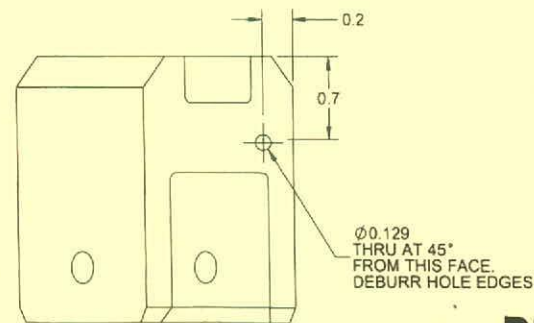
144772 MJS
16-05-05



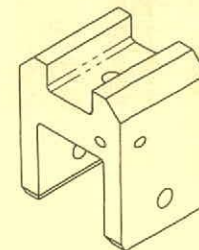
D5106-1 BRACKET



SECTION A-A D5-2



AUXILIARY VIEW D6-2



NOTES:

- 1) MATERIAL: AISI 303/304/316 SS BAR
PER ASTM A582 OR ASTM A240 OR ASTM A276
REF DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5106	SHEET 2 OF 2
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